

Work Order ID 83006***83006***

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Tuesday, April 24, 2012 12:34:30 PM

Item ID: D3808-1

Revision ID:

Item Name: Seat Rail

Start Date: 4/12/2012 Start Qty: 4.00

Required Date: 4/24/2012 Req'd Qty: 4.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

~~Process Plan~~

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3808

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 16.125 " long

RT 12-04-24 (x6)

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA771 Rev: AA & Dwg D3808 Rev: A 2-Tap holes
for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808

6 0 SF 12/04/24

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6 0 SF 12/04/24

Work Order ID 83006

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Item ID: D3808-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Seat Rail

Start Date: 4/12/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

B.A 12/04/27

6

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

(6) 116.124.30

141

QC3- Inspect Part Finish

0.00

141

QC

Memo

0.00

Quality Control

6X9 M-L 12/4/30

Picklist Print

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Work Order ID: 83006

Parent Item: D3808-1

Parent Item Name: Seat Rail

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.250		Purchased	No			100	f	19.5933	1.35	5.6842105		12-04-14	
6061-T6 Bar 2.00 x 1.25													

Location

Loc Qty

Loc Code

MAT009

7.59326358

114899

4.15263158

116623

2.15

119136

1.290632

MAT010

12

121040

12

x 5.6842105 8.06 25

DART AEROSPACE LTD		Work Order:	83006
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	13.9995	✓		Height Gauge	
7.30	+/-0.030	7.3045	✓		11	
0.550	+/-0.010	.5495	✓		SLOS	View
0.85	+/-0.030	.850	✓		↓	
0.780	+/-0.010	.7785	✓		↓	
Ø0.391	+0.006/-0.001	Ø0.395	✓		↓	
3/8-16 UNC	N/A	3/8-16unc	✓		thread gauge	
Ø0.323	+0.006/-0.001	Ø0.324	✓		SLOS	View
Ø0.695 x 100°	+/-0.010 x 0.5°	Ø.698 x 100°	✓		↓	
Ø0.172	+0.005/-0.001	Ø.174	✓		↓	
8-32 UNC	N/A	8-32unc	✓		thread gauge	
0.800 x 0.667 deep	+/-0.010	.798 x .666	✓		SLOS	View
2.00	+/-0.030	2.001	✓		SLOS	
R0.26	+/-0.030	R.0.260	✓		Rad gauge	
6.13	+/-0.030	6.125	✓		SLOS	View
5.13	+/-0.030	5.125	✓		↓	
0.16	+/-0.030	.162	✓		↓	
1.75	+/-0.030	1.7495	✓		↓	
15.88	+/-0.030	15.8785	✓		Height Gauge	
0.965	+/-0.010	.965	✓		SLOS	View
0.375	+/-0.010	0.376	✓		↓	
1.10	+/-0.030	1.100	✓		↓	
0.140	+/-0.010	.141	✓		↓	
0.373	+/-0.010	.3725	✓		↓	
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	✓		↓	
R0.06	+/-0.030	R.06	✓		Rad gauge	
0.347	+/-0.010	.344	✓		SLOS	View
0.270	+0.030/-0.000	.286	✓		↓	
Ø0.720	+0.005/-0.010	Ø.7205	✓		↓	
R0.063	+/-0.010	R.063	✓		Rad gauge	
0.320	+0.020/-0.000	.330	✓			
R0.015	+/-0.010	R.015	✓		Rad gauge	
0.655	+0.015/-0.010	.652	✓		SLOS	View
0.350	+/-0.010	.349	✓		↓	
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	✓		↓	
0.667	+/-0.010	.675	✓		↓	

DART AEROSPACE LTD		Work Order:	23006
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808	Rev: A	Page 2 of 2	

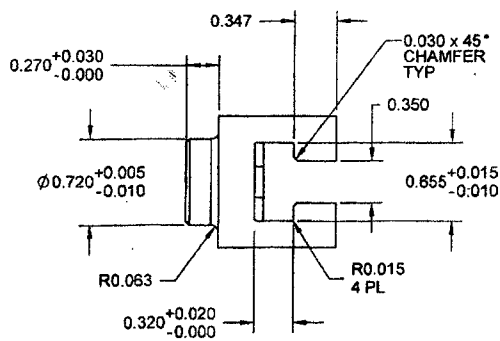
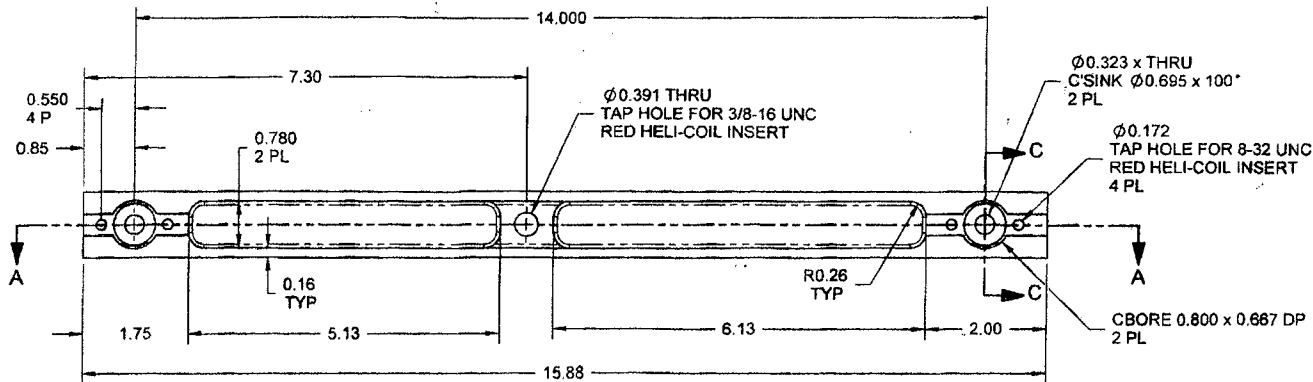
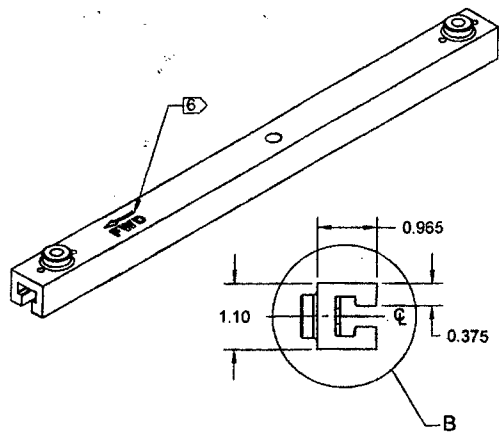
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

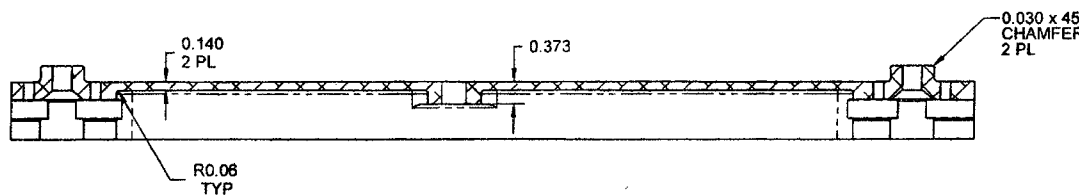
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.156	+/-0.010	.156	✓		SLO8	VEN
Ø0.695	+0.008/-0.001	.698	✓			
Ø0.323	+0.006/-0.001	.324	✓		↓	
Ø0.800	+0.010/-0.001	.798	✓			
R0.031	+/-0.010	R.031	✓		Rad gauge	

Measured by: <i>JS</i>	Audited by: <i>B.A.</i>	Prototype Approval:	N/A
Date: 12/04/26	Date: 12/04/27	Date:	N/A

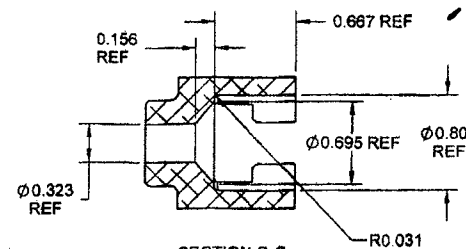
Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ <i>JS</i>	<i>JS</i>



DETAIL VIEW B



SECTION A-A







SECTION C-C

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

w/o 83006

D3808-1 SEAT RAIL

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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